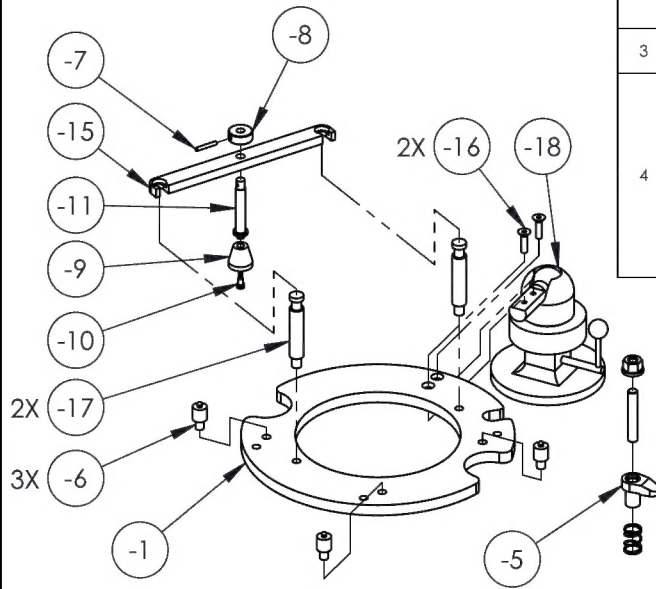
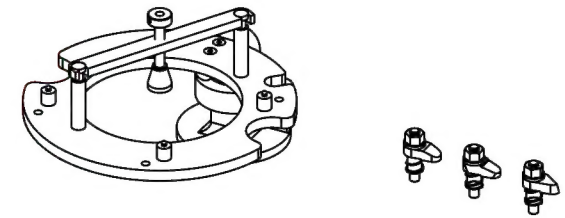


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		FOR -5, -12, -19 HEAT TREAT DROPPED, MATERIAL CHANGED TO 1020.	2/22/2002		
1A		CHANGED REVISION TO NUMERICAL, CH'D TITLEBLOCK & REVISION BLOCK, ADDED ENGRAVE NOTE, CH'D P/N -10 REID P/N, CH'D DWG. NO. FROM 6795966, MOVED PARTS TO NEW SHEETS FOR CLARITY.	6/30/2009	RJC	RW
2	15-0014	UPDATED TO NEW DRAFTING STANDARDS. -1 CH'D DIMS WAS 2X DRILL & CSK FOR 5/16 FLHD SCREW IS 2X Ø.33 THRU ALL ✓ Ø.64 X 82°. WAS 3X Ø.437 THRU PF -6 IS 3X LIMITS Ø.4375-.4382 THRU ALL. ADDED FINISH SPEC MIL-A-8625F, TYPE II, CLASS II. -5A CH'D DIM WAS Ø.750 IS Ø.750 S.F. -5B. -5B CH'D DIMS WAS Ø.750 IS (Ø.750). WAS Ø.50 IS (Ø.500). -6 CH'D DIM WAS Ø.437 PF -1 IS LIMITS Ø.4387-.4391. -7 CH'D B/O INFO WAS #DL-146 IS #98381A512. -8 CH'D DIM WAS Ø.437 THRU SF -11 IS LIMITS Ø.4375-.4382. ADDED KNURL NOTE. -9 CH'D DIM WAS Ø1.25 IS (Ø1.250). -11 CH'D DIMS WAS Ø.188 THRU PF -7 IS LIMITS Ø.1869-.1874, WAS Ø.750 IS (Ø.750). -15 CH'D DIMS WAS .50 IS (.500). WAS .532 IS 2X .532 IS 2X FULL R. -16 ADDED B/O INFO #91253A585. -17 CH'D UNDERCUT AND ADDED DETAIL A. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	1/13/2015	DPD	JAG
3	15-0116	-1 IMPROVED HOLE CALLOUTS. -8 CH'D MAT'L WAS A36 IS 1018/1020. -17 CORRECTED THREAD CALLOUT WAS 1/2-20 UNC-2A IS 1/2-13 UNC-2A. DELETED DIMS .08, R.03. ADDED THREAD RELIEF.	5/21/2015	DPD	JAG
4	17-0092	-1 CH'D FINISH SPEC WAS MIL-A-8625F, TYPE II, CLASS II IS MIL-A-8625F, TYPE II, CLASS I. -5, -6, -8, -11, -12, -15, -17, -19 ADDED FINISH SPEC QMSI-6.2.2, B.O REV D. -5A, -12A, -19A, -8, -15 CH'D MATERIAL WAS 1018/1020 IS A36/1018/1020 HR. -5 DELETED HEAT TREAT RC 32-36. -5A CH'D DIM WAS Ø.750 THRU ALL S.F. -5B IS Ø.7595/7575 THRU ALL (S.F. -5B). WAS Ø.313 √.188 IS Ø.313 √.19. -5B ADDED DIMS .360 +.005/- .000, Ø.7495/7491 (S.F. -5A, -12A, -19A). CH'D MAT'L WAS 1018/1020 IS DOM. -8 CH'D DIM WAS Ø.4382/4375 THRU ALL IS Ø.4382/4375 THRU ALL (S.F. -11). WAS Ø.1883/1880 THRU ALL IS Ø.1883/1880 THRU ALL (S.F. -7). -9 CH'D DIM WAS Ø.375 ±.001 IS Ø.375 ±.001 (S.F. -11). -11 CH'D DIMS WAS Ø.371 ±.001 IS Ø.371 ±.001 (S.F. -9). WAS Ø.4359/4349 IS Ø.4359/4349 (S.F. -8). WAS Ø.1874/1869 THRU IS 1874/1869 THRU (P.F. -7). -10 CH'D MATERIAL WAS STEEL IS S.S. CH'D B/O P/N WAS ESSENTA COMPONENTS #MMS-1 IS #MMS-2. -12 DELETED HEAT TREAT RC 32-36. -12A CH'D DIMS WAS Ø.750 THRU ALL S.F. -5B IS Ø.7595/7575 THRU ALL (S.F. -5B). WAS Ø.313 √.188 IS Ø.313 √.19. -17 CH'D MAT'L WAS 1018/1020 IS 1018/1020 CR. -19 DELETED HEAT TREAT RC 32-36. -19A CH'D DIM WAS Ø.750 THRU ALL S.F. -5B IS Ø.7595/7575 THRU ALL (S.F. -5B). WAS Ø.313 √.188 IS Ø.313 √.19.	4/19/2017	RJC	JAG



**UNDER REVIEW**  
URF 19-750 19.05.30 (VM)

ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				-1	1	PLATE	6061		2
			B/O	-2	3	SPRING	STEEL	Ø.906 O.D. X Ø.782 I.D. X Ø.062 WIRE X 1.310, 12 LBS/IN (CENTURY #2881)	1
			B/O	-3	3	NUT - HEX FLANGE	STEEL	1/2-13 (ESSENTA COMPONENTS #FNC-5)	1
			B/O	-4	3	STUD	STEEL	1/2-13 X 3 (ESSENTA COMPONENTS #AMS-242)	1
		X		-5	1	TOE CLAMP WELDMENT			3
		1		-5A		TOE CLAMP	A36/1018/1020 HR		4
1	1	1		-5B		TOE CLAMP TUBE	DOM		5
				-6	3	LOCATING BUTTON	01		6
			B/O	-7	1	PIN	STEEL	Ø3/16 X 1-1/4 (MCMaster-CARR #98381A512)	1
				-8	1	Knob	A36/1018/1020 HR		7
				-9	1	SHOE	BRASS		8
			B/O	-10	1	SCREW - SHOULDER	S.S.	10-24 X 3/8 X Ø1/4 X 3/8 (ESSENTA COMPONENTS #MMS-2)	1
				-11	1	JACK SCREW	STRESSPROOF OR 41L40		9
		X		-12	1	TOE CLAMP WELDMENT			10
		1		-12A		TOE CLAMP	A36/1018/1020 HR		11
				-15	1	BAR	A36/1018/1020 HR		12
			B/O	-16	2	SCREW - F.H. SOCKET	STEEL	5/16-18 X 1-1/4 (MCMaster-CARR #91253A585)	1
				-17	2	POST	1018/1020 CR		13
			B/O	-18	1	POWER ARM	(WILTON #301)		14
		X		-19	1	TOE CLAMP WELDMENT			15
		1		-19A		TOE CLAMP	A36/1018/1020 HR		15
ASSY -19	ASSY -12	ASSY -5							

NOTE:  
REFERENCE ROLLS ROYCE T/N 6795966.

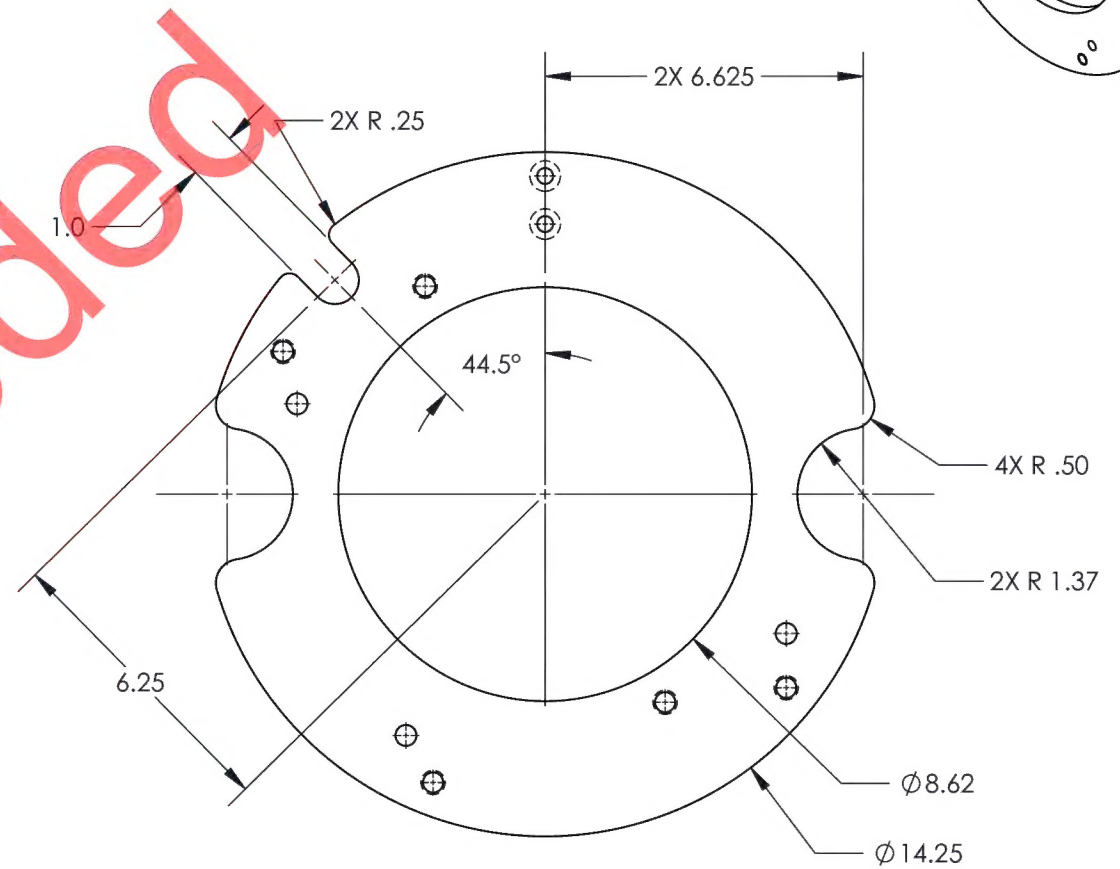
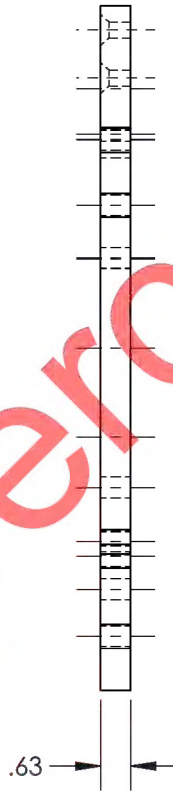
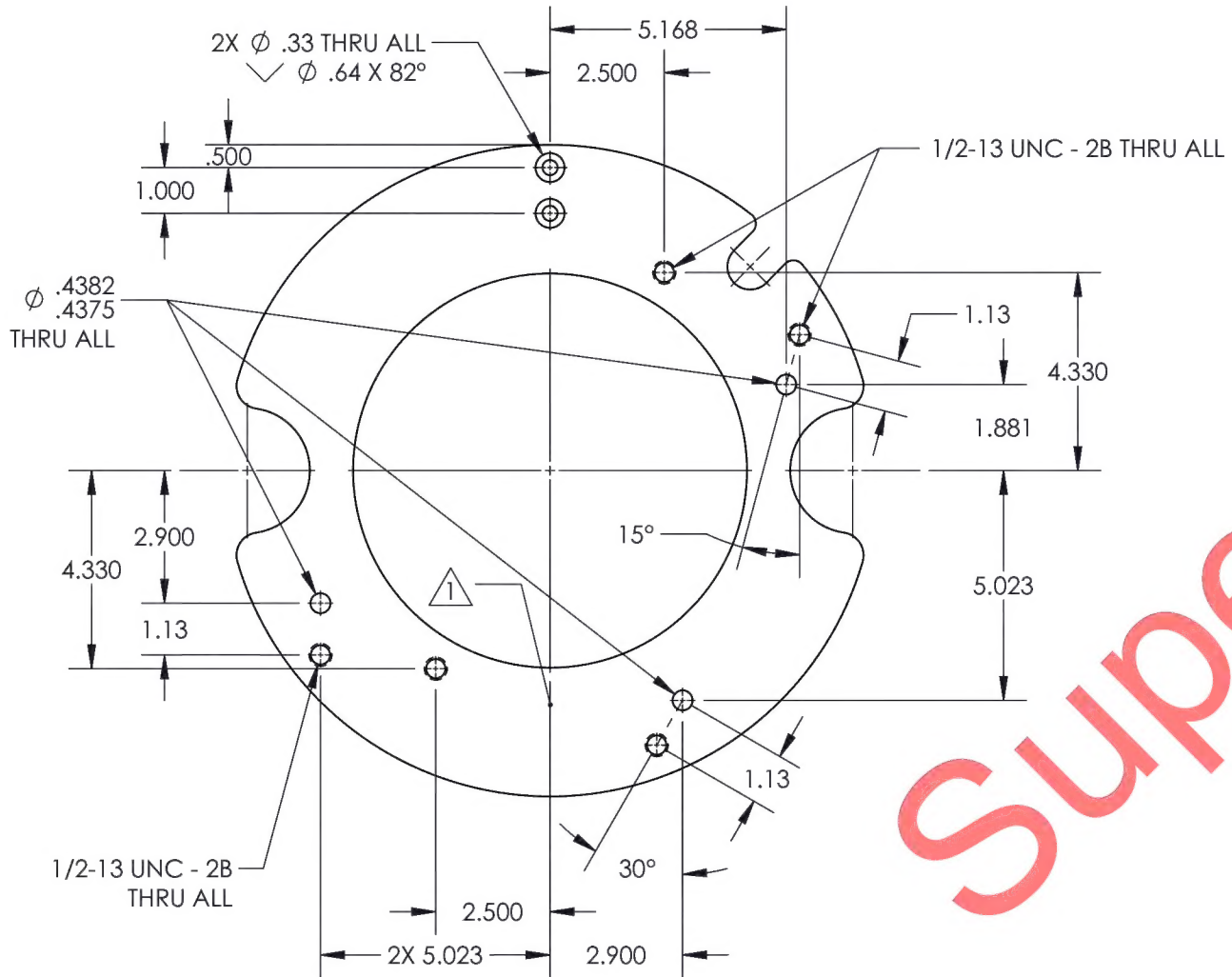
**DART**  
AEROSPACE

TITLE  
**FIXTURE - ASSY, COMPRESSOR**


DWG NO.	RB6795966	REV	4
MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125√		
HEAT TREAT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		
FINISH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING		
SPEC	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009		
DRAWN BY:	COLE		
CHECKED:	DD 04/21/2017		
OPPS APPR:	AA 05/09/2017		
QA APPR:	JL 05/10/2017		
APPROVED:	JAG 05/16/2017		
SCALE	1:10	DATE	2/22/2002
		SHEET 1 OF 15	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0014	-1 CH'D DIMS WAS 2X DRILL & CSK FOR 5/16 FLHD SCREW IS 2X Ø.33 THRU ALL ✓ Ø.64 X 82°, WAS 3X Ø.437 THRU PF -6 IS 3X LIMITS Ø.4375-.4382 THRU ALL. ADDED FINISH SPEC MIL-A-8265F, TYPE II, CLASS II.	1/13/2015	DPD	JAG
3	15-0116	-1 IMPROVED HOLE CALLOUTS.	5/21/2015	DPD	JAG
4	17-0092	-1 CH'D FINISH SPEC WAS MIL-A-8625F, TYPE II, CLASS II IS MIL-A-8625F, TYPE II, CLASS I.	4/19/2017	RJC	JAG



1 ENGRAVE T/N, S/N, "MADE IN USA".

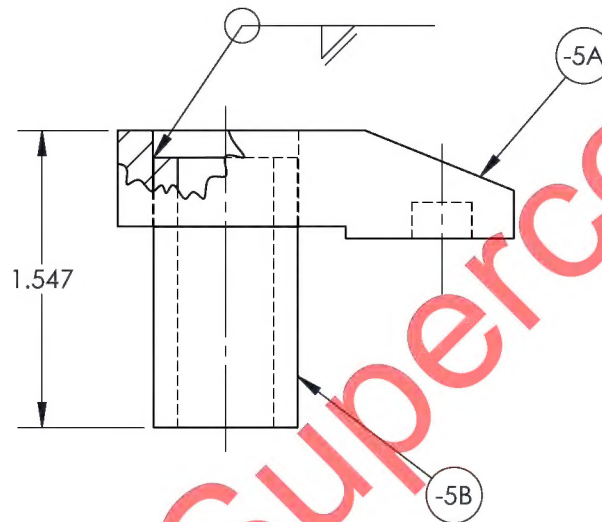
		
TITLE <b>FIXTURE - ASSY, COMPRESSOR</b>		
DWG NO.		REV <b>4</b>
<b>RB6795966-1</b>		
MAT'L 6061 HEAT TREAT FINISH CLEAR ANODIZE SPEC MIL-A-8625F, TYPE II, CLASS I		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/√
DRAWN BY: COLE CHECKED: DD 04/21/2017 QPPS APPR: AA 05/09/2017 QA APPR: JL 05/10/2017		1. BREAK ALL SHARP EDGES 0.15 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: JAG 05/16/2017		USED ON MODEL <b>ALLISON 250 SERIES</b>
SCALE 1:4	DATE 2/22/2002	SHEET 2 OF 15

**UNDER REVIEW**  
URF 19-750 19.05.30 (VM)

PLATE

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	17-0092	-5 ADDED FINISH SPEC QMSI-6.2.2, B.O REV D. DELETED HEAT TREAT RC 32-36.	4/19/2017	RJC	JAG



**UNDER REVIEW**  
URF 19-750 19.05.30 (VM)

NOTE:  
NO WELD INSIDE -5B TOE CLAMP TUBE .

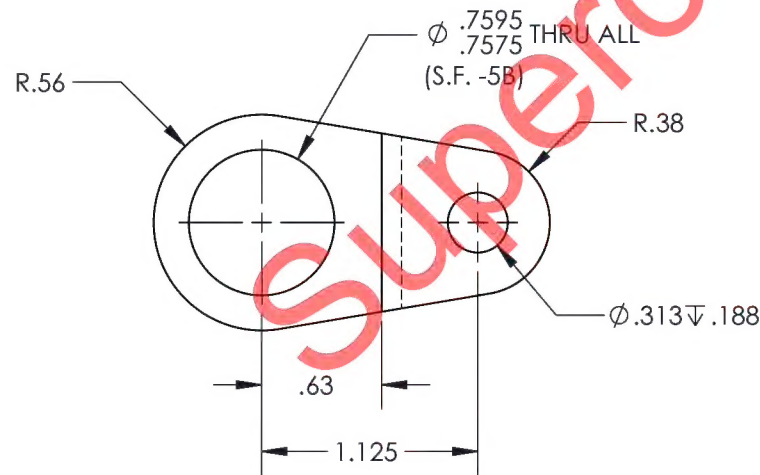
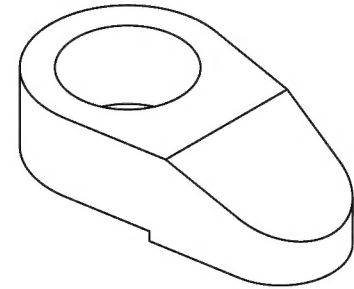
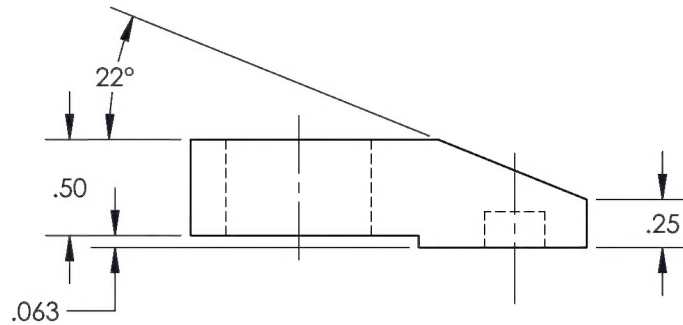
(5)  
TOE CLAMP WELDMENT

<b>DART AEROSPACE</b>	
TITLE <b>FIXTURE - ASSY, COMPRESSOR</b>	
DWG NO. <b>RB6795966-5</b>	REV <b>4</b>
MAT'L REAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 04/21/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 05/09/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 05/10/2017	USED ON MODEL
APPROVED: JAG 05/16/2017	ALLISON 250 SERIES
SCALE 1:1	DATE 2/22/2002 SHEET 3 OF 15



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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0014	-5A CH'D DIMS WAS Ø.750 IS Ø.750 S.F. -5B.	1/13/2015	DPD	JAG
4	17-0092	-5A CH'D DIM WAS Ø.750 THRU ALL S.F. -5B IS Ø.7595/.7575 THRU ALL (S.F. -5B). WAS Ø.313 $\nabla$ .188 IS Ø.313 $\nabla$ .19. CH'D MATERIAL WAS 1018/1020 IS A36/1018/1020 HR.	4/19/2017	RJC	JAG



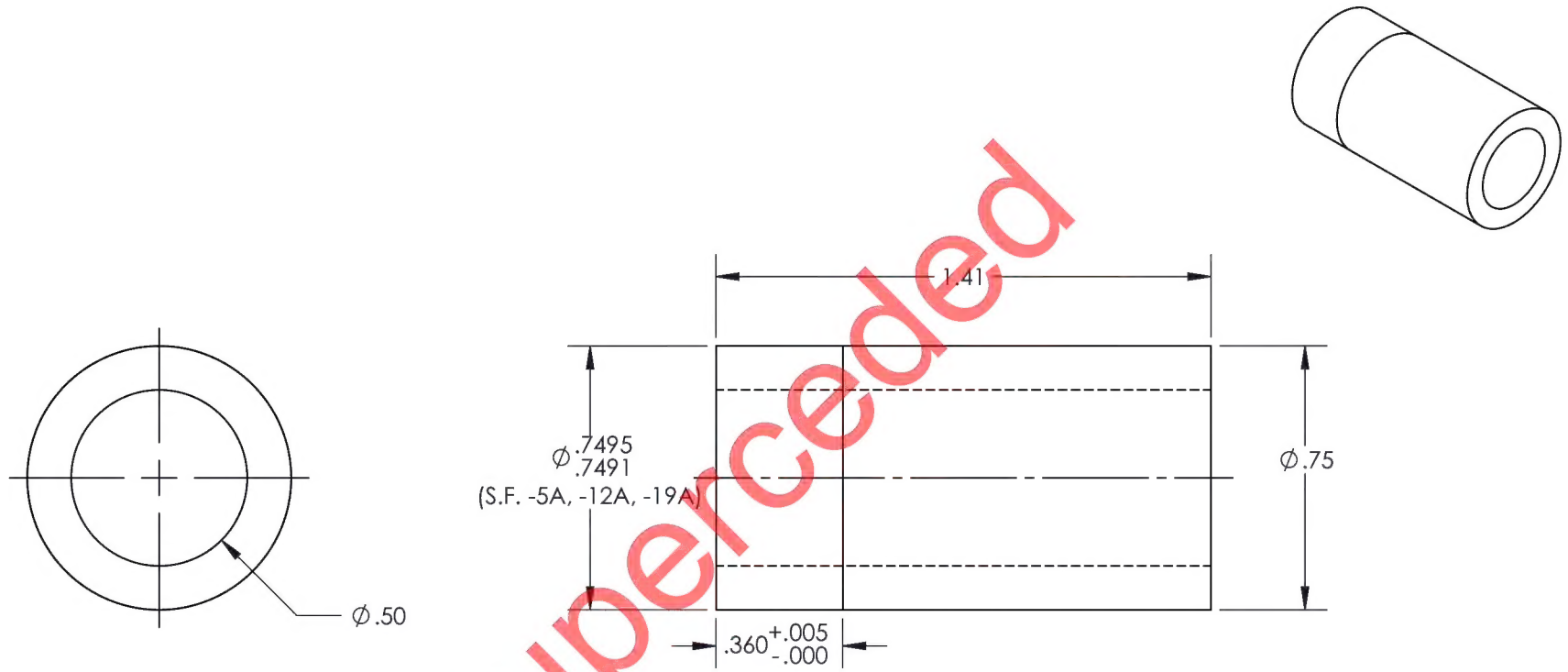
**UNDER REVIEW**  
URF 19-750 19.05.30 (VM)

(-5A)  
TOE CLAMP

<b>DART AEROSPACE</b>	
TITLE <b>FIXTURE - ASSY, COMPRESSOR</b>	
DWG NO. <b>RB6795966-5A</b>	REV <b>4</b>
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX $\pm$ .005 FRACTIONS $\pm$ 1/8
FINISH SEE -5 WELDMENT	.XX $\pm$ .01 ANGLES $\pm$ 5°
SPEC	.X $\pm$ .1 SURFACES = 125° ✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 04/21/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 05/09/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 05/10/2017	USED ON MODEL
APPROVED: JAG 05/16/2017	ALLISON 250 SERIES
SCALE 1:1	DATE 2/22/2002
SHEET 4 OF 15	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0014	-5B CH'D DIMS WAS Ø.750 IS (Ø.750), WAS Ø.50 IS (Ø.500).	1/13/2015	DPD	JAG
4	17-0092	-5B ADDED DIM'S .360 +.005/- .000, Ø.7495/.7491 (S.F. -5A, -12A, -19A). CH'D MAT'L WAS 1018/1020 IS DOM.	4/19/2017	RJC	JAG



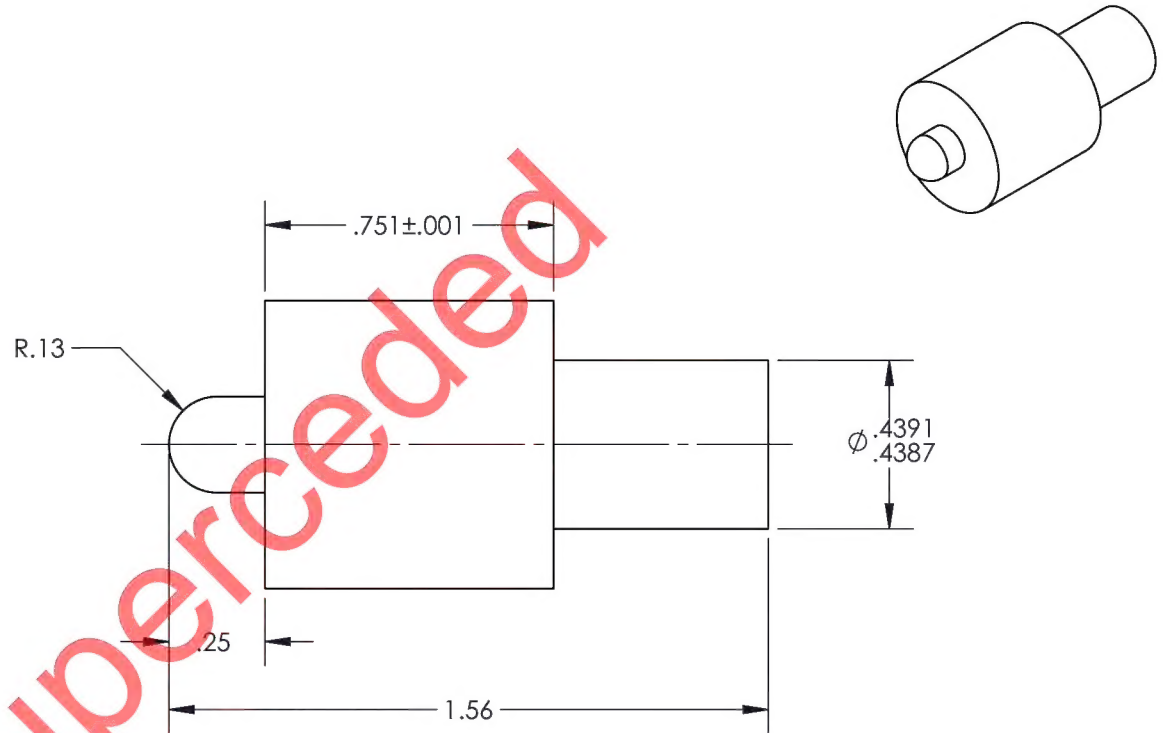
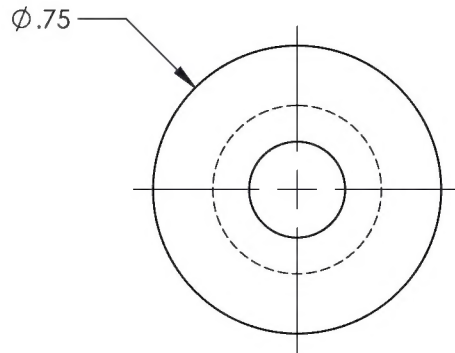
**UNDER REVIEW**  
URF 19-750 19.05.30 (VM)

(-5B)  
TOE CLAMP TUBE

<b>DART AEROSPACE</b>																															
TITLE <b>FIXTURE - ASSY, COMPRESSOR</b>																															
DWG NO. <b>RB6795966-5B</b>	REV <b>4</b>																														
<table border="1"> <tr> <td>MAT'L</td> <td>DOM</td> <td rowspan="4">           UNLESS OTHERWISE SPECIFIED            DIMENSIONS ARE IN INCHES            .XXX ± .005 FRACTIONS ± 1/8            .XX ± .01 ANGLES ± .5°            .X ± .1 SURFACES = 125° ✓         </td> </tr> <tr> <td>HEAT TREAT</td> <td></td> </tr> <tr> <td>FINISH</td> <td>SEE WELDMENTS -5, -12, -19</td> </tr> <tr> <td>SPEC</td> <td></td> </tr> <tr> <td>DRAWN BY:</td> <td>COLE</td> <td>1. BREAK ALL SHARP EDGES .015 x 45° OR .015R</td> </tr> <tr> <td>CHECKED:</td> <td>DD 04/21/2017</td> <td>2. DIMENSIONAL LIMITS APPLY AFTER PLATING</td> </tr> <tr> <td>OPPS APPR:</td> <td>AA 05/09/2017</td> <td>3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</td> </tr> <tr> <td>QA APPR:</td> <td>JL 05/10/2017</td> <td>USED ON MODEL</td> </tr> <tr> <td>APPROVED:</td> <td>JAG 05/16/2017</td> <td>ALLISON 250 SERIES</td> </tr> <tr> <td>SCALE</td> <td>2:1</td> <td>DATE 2/22/2002</td> </tr> <tr> <td colspan="2"></td> <td>SHEET 5 OF 15</td> </tr> </table>		MAT'L	DOM	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125° ✓	HEAT TREAT		FINISH	SEE WELDMENTS -5, -12, -19	SPEC		DRAWN BY:	COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	CHECKED:	DD 04/21/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	OPPS APPR:	AA 05/09/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	QA APPR:	JL 05/10/2017	USED ON MODEL	APPROVED:	JAG 05/16/2017	ALLISON 250 SERIES	SCALE	2:1	DATE 2/22/2002			SHEET 5 OF 15
MAT'L	DOM	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125° ✓																													
HEAT TREAT																															
FINISH	SEE WELDMENTS -5, -12, -19																														
SPEC																															
DRAWN BY:	COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R																													
CHECKED:	DD 04/21/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING																													
OPPS APPR:	AA 05/09/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009																													
QA APPR:	JL 05/10/2017	USED ON MODEL																													
APPROVED:	JAG 05/16/2017	ALLISON 250 SERIES																													
SCALE	2:1	DATE 2/22/2002																													
		SHEET 5 OF 15																													

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0014	-6 CH'D DIM WAS Ø.437 PF -1 IS LIMITS Ø.4387-.4391.	1/13/2015	DPD	JAG
4	17-0092	-6 ADDED FINISH SPEC QMSI-6.2.2, B.O REV D.	4/19/2017	RJC	JAG



Supercircled

**UNDER REVIEW**  
URF 19-750 19.05.30 (VM)

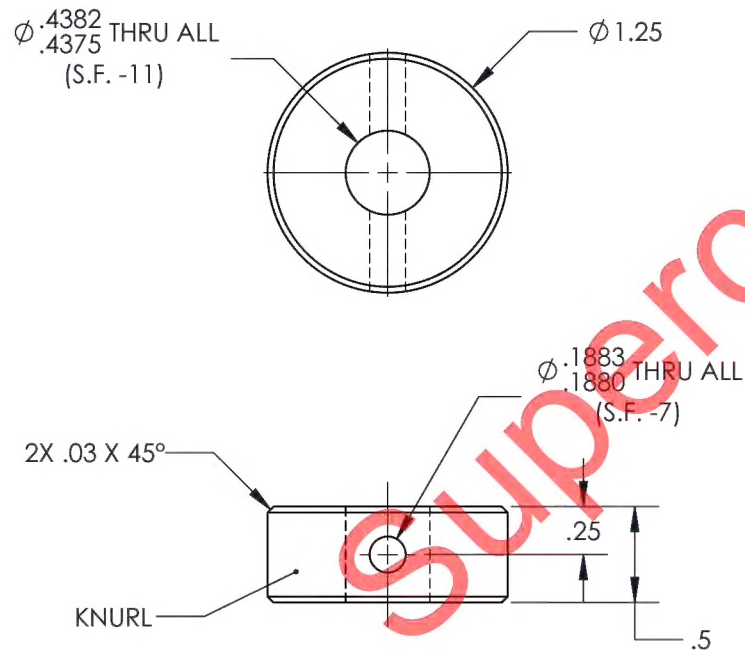
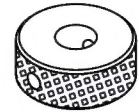
(-6)

LOCATING BUTTON

<b>DART AEROSPACE</b>	
TITLE: <b>FIXTURE - ASSY, COMPRESSOR</b>	
DWG NO. <b>RB6795966-6</b>	REV <b>4</b>
MAT'L 01	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 50-60	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED: DD 04/21/2017	.015 x 45° OR .015R
OPPS APPR: AA 05/09/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 05/10/2017	AFTER PLATING
APPROVED: JAG 05/16/2017	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 2:1	DATE 2/22/2002
	SHEET 6 OF 15

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0014	-8 CH'D DIM WAS Ø.437 THRU SF -11 IS LIMITS Ø.4375-.4382. ADDED DIM LIMITS Ø.1880-.1883. ADDED KNURL NOTE.	1/13/2015	DPD	JAG
3	15-0116	-8 CH'D MAT'L WAS A36 IS 1018/1020.	5/21/2015	DPD	JAG
4	17-0092	-8 CH'D DIM WAS Ø.4382/.4375 THRU ALL IS Ø.4382/.4375 THRU ALL (S.F. -11), WAS Ø.1883/.1880 THRU ALL IS Ø.1883/.1880 THRU ALL (S.F. -7). CH'D MAT'L WAS 1018/1020 IS A36/1018/1020 HR. ADDED FINISH SPEC QMSI-6.2.2, B.O REV D.	4/19/2017	RJC	JAG



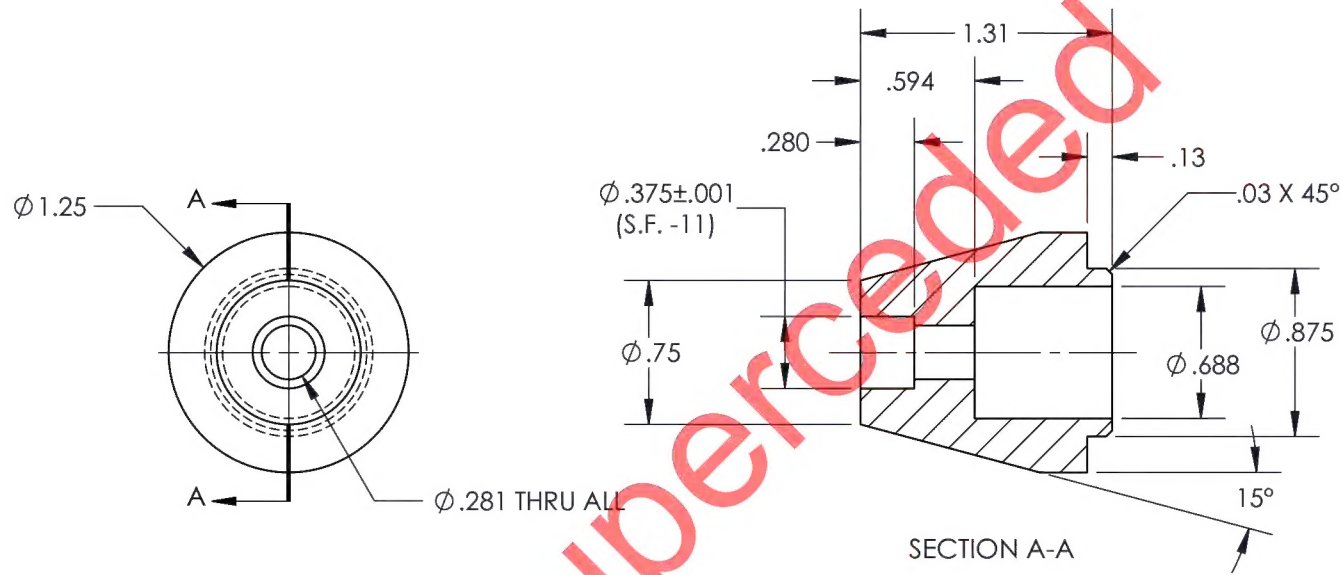
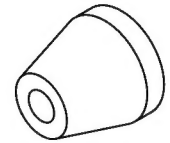
**UNDER REVIEW**  
URF 19-750 19.05.30 (VM)

(-8)  
KNOB

<b>DART AEROSPACE</b>	
TITLE <b>FIXTURE - ASSY, COMPRESSOR</b>	
DWG NO. <b>RB6795966-8</b>	REV <b>4</b>
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± 5°
SPEC QMSI-6.2.2, B.O. REV D	.X ± .1 SURFACES = 125✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 04/21/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 05/09/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 05/10/2017	USED ON MODEL
APPROVED: JAG 05/16/2017	ALLISON 250 SERIES
SCALE 1:1	DATE 2/22/2002
SHEET 7 OF 15	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0014	-9 CH'D DIM WAS Ø1.25 IS (Ø1.250).	1/13/2015	DPD	JAG
4	17-0092	-9 CH'D DIM WAS Ø.375 ±.001 IS Ø.375 ±.001 (S.F. -11).	4/19/2017	RJC	JAG



**UNDER REVIEW**  
URF 19-750 19.05.30 (VM)

⑨

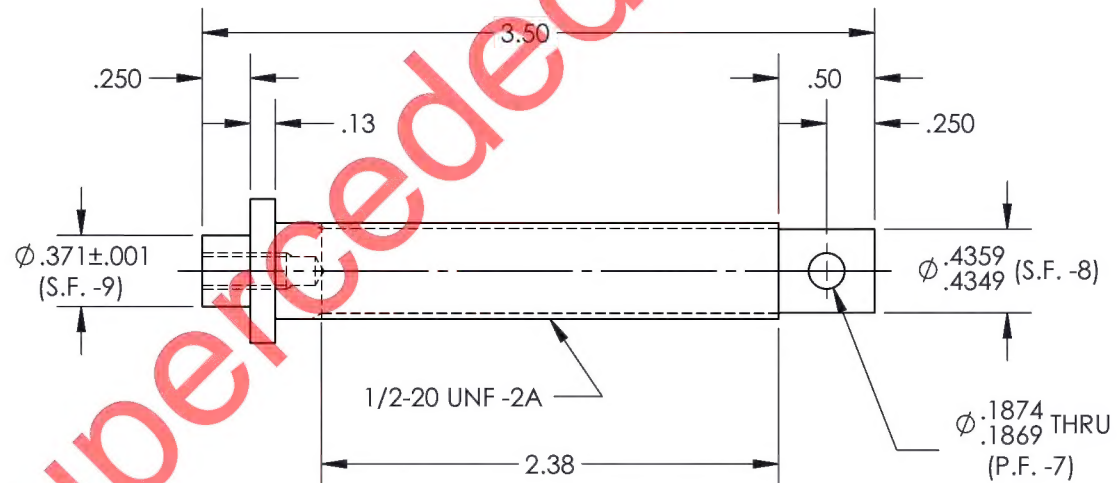
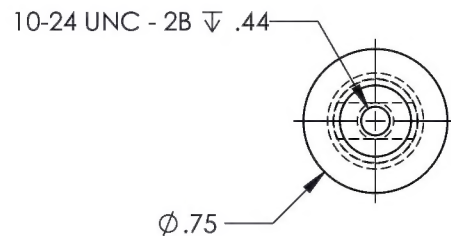
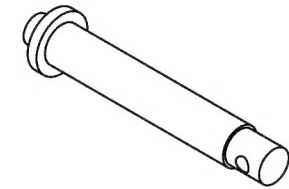
SHOE

<b>DART AEROSPACE</b>	
TITLE <b>FIXTURE - ASSY, COMPRESSOR</b>	
DWG NO. <b>RB6795966-9</b>	REV <b>4</b>
MAT'L BRASS	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125°
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES
CHECKED: DD 04/21/2017	.015 x 45° OR .015R
OPPS APPR: AA 05/09/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 05/10/2017	AFTER PLATING
APPROVED: JAG 05/16/2017	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	ALLISON 250 SERIES
SCALE 1:1	DATE 2/22/2002
	SHEET 8 OF 15



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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0014	-11 CH'D DIMS WAS Ø.188 THRU PF -7 IS LIMITS Ø.1869-.1874, WAS Ø.750 IS (Ø.750).	1/13/2015	DPD	JAG
4	17-0092	-11 CH'D DIM'S WAS Ø.371 ±.001 IS Ø.371 ±.001 (S.F. -9), WAS Ø.4359/.4349 IS Ø.4359/.4349 (S.F. -8), WAS Ø.1874/.1869 THRU IS .1874/.1869 THRU (P.F. -7). ADDED FINISH SPEC QMSI-6.2.2, B.O REV D.	4/19/2017	RJC	JAG



Superseded

**UNDER REVIEW**  
URF 19-750 19.05.30 (VM)

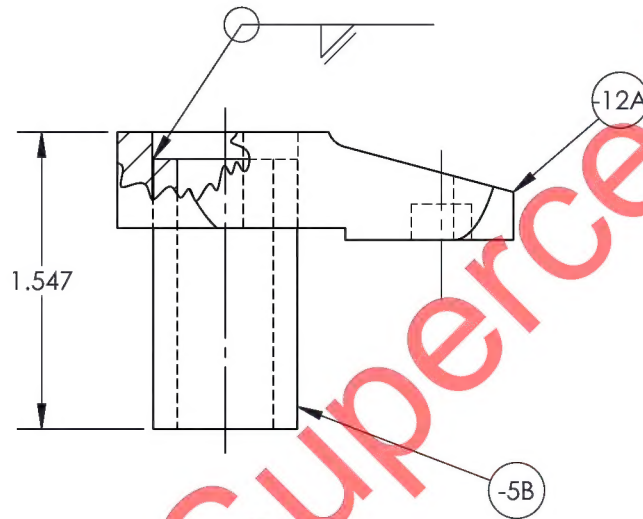
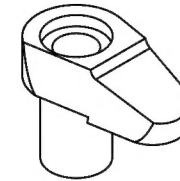
(11)

JACK SCREW

<b>DART AEROSPACE</b>	
TITLE <b>FIXTURE - ASSY, COMPRESSOR</b>	
DWG NO. <b>RB6795966-11</b>	REV <b>4</b>
MAT'L STRESSPROOF OR 41L40 HEAT TREAT FINISH BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: <b>COLE</b>	USED ON MODEL
CHECKED: <b>DD 04/21/2017</b>	ALLISON 250 SERIES
OPPS APPR: <b>AA 05/09/2017</b>	
QA APPR: <b>JL 05/10/2017</b>	
APPROVED: <b>JAG 05/16/2017</b>	
SCALE <b>1:1</b>	DATE <b>2/22/2002</b>
SHEET 9 OF 15	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	17-0092	-12 DELETED HEAT TREAT RC 32-36. ADDED FINISH SPEC QMSI-6.2.2, B.O REV D.	4/19/2017	RJC	JAG



**UNDER REVIEW**  
URF 19-750 19.05.30 (VM)

NOTE:  
NO WELD INSIDE -5B TOE CLAMP TUBE.



TITLE  
**FIXTURE - ASSY, COMPRESSOR**

DWG NO. **RB6795966-12** REV **4**

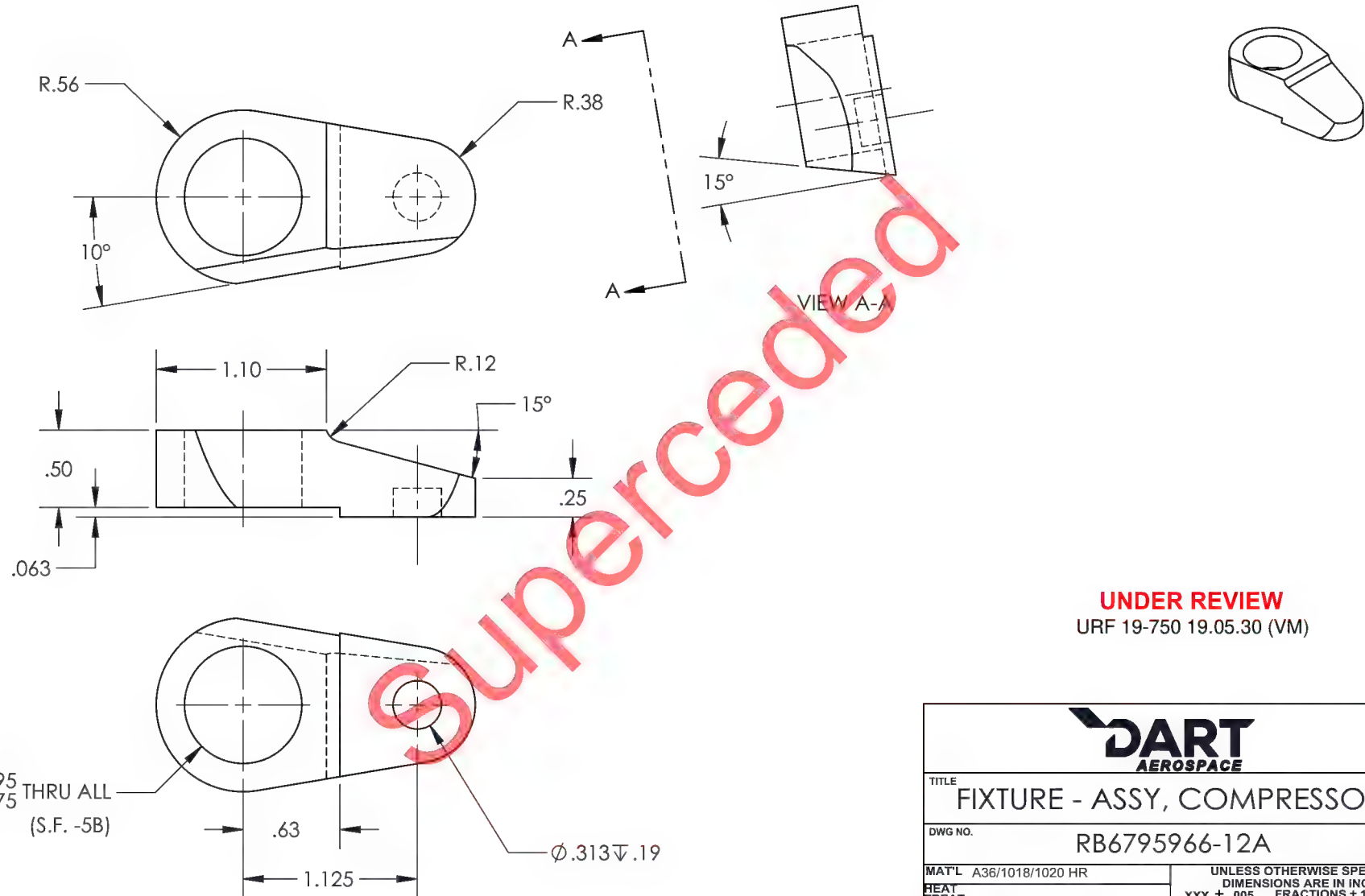
MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH BLACK OXIDE		.XXX ± .005	FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D		.XX ± .01	ANGLES ± 5°
DRAWN BY: COLE		.X ± .1	SURFACES = 125✓
CHECKED: DD 04/21/2017		1. BREAK ALL SHARP EDGES	
OPPS APPR: AA 05/09/2017		.015 x 45° OR .015R	
QA APPR: JL 05/10/2017		2. DIMENSIONAL LIMITS APPLY	
APPROVED: JAG 05/16/2017		AFTER PLATING	
SCALE 1:1		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE 2/22/2002		USED ON MODEL	
SHEET 10 OF 15		ALLISON 250 SERIES	

-12

TOE CLAMP WELDMENT

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	17-0092	-12A CH'D DIM'S WAS Ø.750 THRU ALL S.F. -5B IS Ø.7595/.7575 THRU ALL (S.F. -5B), WAS Ø.313 $\nabla$ .188 IS Ø.313 $\nabla$ .19. CH'D MATERIAL WAS 1018/1020 IS A36/1018/1020 HR.	4/19/2017	RJC	JAG



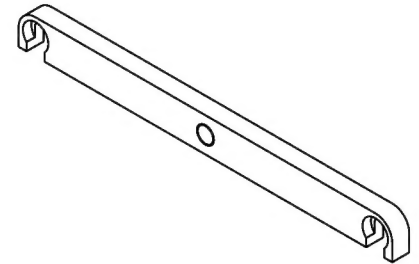
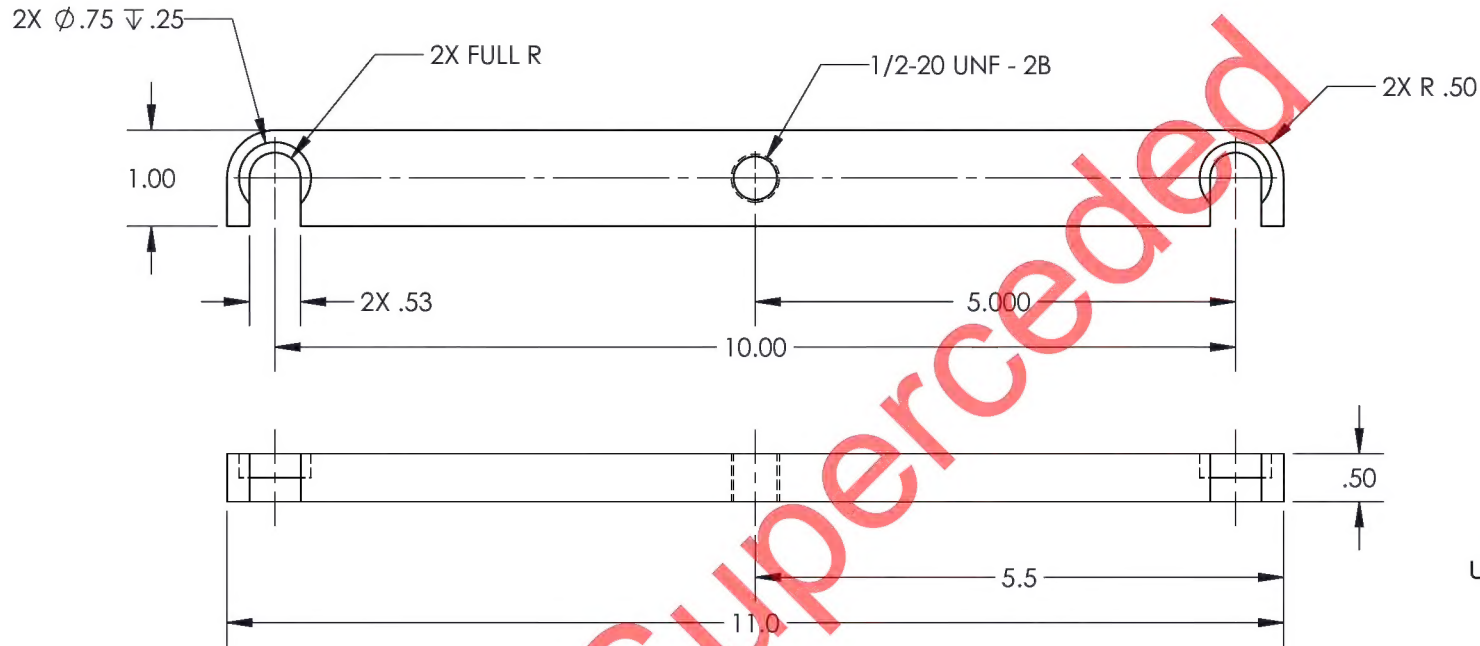
**UNDER REVIEW**  
URF 19-750 19.05.30 (VM)

(-12A)  
TOE CLAMP

<b>DART AEROSPACE</b>	
TITLE <b>FIXTURE - ASSY, COMPRESSOR</b>	
DWG NO. <b>RB6795966-12A</b>	REV <b>4</b>
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX $\pm$ .005 FRACTIONS $\pm$ 1/8
FINISH SEE -12 WELDMENT	.XX $\pm$ .01 ANGLES $\pm$ 5°
SPEC	.X $\pm$ .1 SURFACES = 125° ✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 04/21/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 05/09/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 05/10/2017	USED ON MODEL
APPROVED: JAG 05/16/2017	ALLISON 250 SERIES
SCALE 1:1	DATE 2/22/2002
SHEET 11 OF 15	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0014	-15 CH'D DIMS WAS .50 IS (.500), WAS .532 IS 2X .532, WAS Ø.532 IS 2X FULL R.	1/14/2015	DPD	JAG
4	17-0092	-15 ADDED FINISH SPEC QMSI-6.2.2, B.O REV D. CH'D MAT'L WAS 1018/1020 IS A36/1018/1020 HR.	4/19/2017	RJC	JAG



**UNDER REVIEW**  
URF 19-750 19.05.30 (VM)

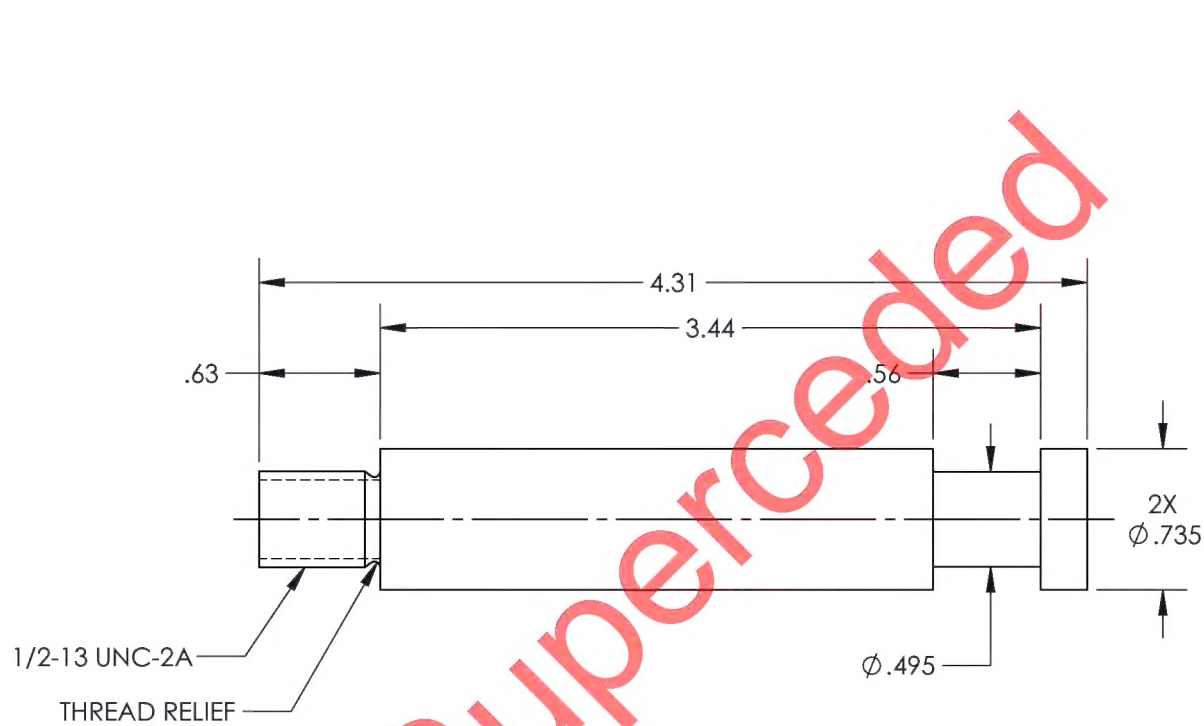
(-15)  
BAR

<b>DART AEROSPACE</b>	
TITLE <b>FIXTURE - ASSY, COMPRESSOR</b>	
DWG NO. <b>RB6795966-15</b>	REV <b>4</b>
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH BLACK OXIDE	.XX ± .01 ANGLES ± 5°
SPEC QMSI-6.2.2, B.O. REV D	.X ± .1 SURFACES = 125°
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 04/21/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 05/09/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 05/10/2017	USED ON MODEL
APPROVED: JAG 05/16/2017	ALLISON 250 SERIES
SCALE 1:2	DATE 2/22/2002
SHEET 12 OF 15	



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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	15-0014	-17 CH'D UNDERCUT AND ADDED DETAIL A.	1/14/2015	DPD	JAG
3	15-0116	-17 CORRECTED THREAD CALLOUT WAS 1/2-20 UNC-2A IS 1/2-13 UNC-2A. DELETED DIMS .08, R.03. ADDED THREAD RELIEF.	5/21/2015	DPD	JAG
4	17-0092	-17 ADDED FINISH SPEC QMSI-6.2.2, B.O REV D.	4/19/2017	RJC	JAG



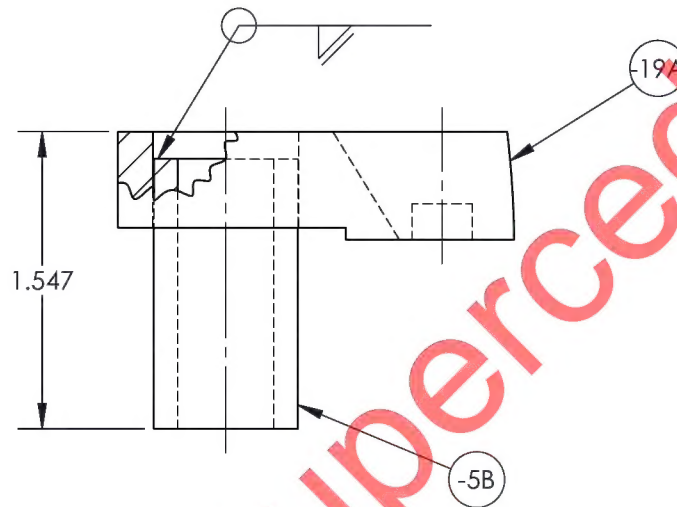
**UNDER REVIEW**  
URF 19-750 19.05.30 (VM)

(-17)  
POST

<b>DART AEROSPACE</b>	
TITLE <b>FIXTURE - ASSY, COMPRESSOR</b>	
DWG NO. <b>RB6795966-17</b>	REV <b>4</b>
MAT'L 1018/1020 CR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH BLACK OXIDE	.XXX ± .005 FRACTIONS ± 1/8
SPEC QMSI-6.2.2, B.O. REV D	.XX ± .01 ANGLES ± 5°
DRAWN BY: COLE	.X ± .1 SURFACES = 125
CHECKED: DD 04/21/2017	1. BREAK ALL SHARP EDGES
OPPS APPR: AA 05/09/2017	.015 x 45° OR .015R
QA APPR: JL 05/10/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
APPROVED: JAG 05/16/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:1	DATE 2/22/2002
SHEET 13 OF 15	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	17-0092	-19 DELETED HEAT TREAT RC 32-36. ADDED FINISH SPEC QMSI-6.2.2, B.O REV D.	4/19/2017	RJC	JAG



**UNDER REVIEW**  
URF 19-750 19.05.30 (VM)

NOTE:  
NO WELD INSIDE -5B TOE CLAMP TUBE.

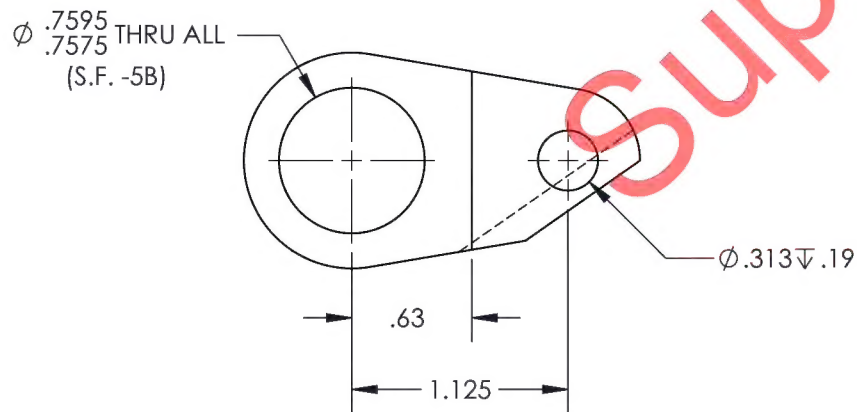
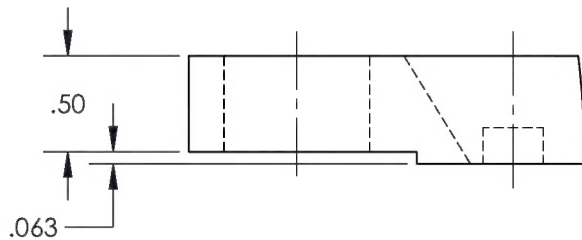
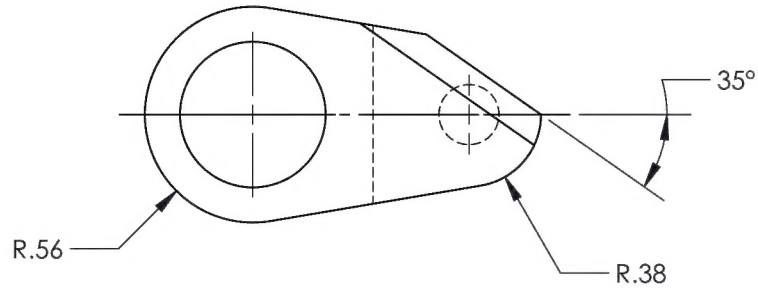
(-19)

TOE CLAMP WELDMENT

<b>DART AEROSPACE</b>	
TITLE <b>FIXTURE - ASSY, COMPRESSOR</b>	
DWG NO. <b>RB6795966-19</b>	REV <b>4</b>
MAT'L HEAT TREAT FINISH BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 04/21/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 05/09/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 05/10/2017	USED ON MODEL
APPROVED: JAG 05/16/2017	ALLISON 250 SERIES
SCALE 1:1	DATE 2/22/2002
SHEET 14 OF 15	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	17-0092	-19A CH'D DIM WAS Ø.750 THRU ALL S.F. -5B IS Ø.7595/.7575 THRU ALL (S.F. -5B), WAS Ø.313 $\nabla$ .188 IS Ø.313 $\nabla$ .19. CH'D MATERIAL WAS 1018/1020 IS A36/1018/1020 HR.	4/19/2017	RJC	JAG



(-19A)

TOE CLAMP

VIEW A-A

**UNDER REVIEW**  
URF 19-750 19.05.30 (VM)

<b>DART AEROSPACE</b>	
TITLE <b>FIXTURE - ASSY, COMPRESSOR</b>	
DWG NO. <b>RB6795966-19A</b>	REV <b>4</b>
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX $\pm$ .005 FRACTIONS $\pm$ 1/8
FINISH SEE -19 WELDMENT	.XX $\pm$ .01 ANGLES $\pm$ 5°
SPEC	.X $\pm$ .1 SURFACES = 125° ✓
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 04/21/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 05/09/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 05/10/2017	USED ON MODEL
APPROVED: JAG 05/16/2017	ALLISON 250 SERIES
SCALE 1:1	DATE 2/22/2002
SHEET 15 OF 15	